DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-019479
Date Inspected: 25-Jan-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC)

OSM Arrival Time: 700
OSM Departure Time: 1500
Location: Shanghai, China

CWI Name:	N/A			**CWI Present:**	☑ Yes	☐ No		
Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A	
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A	
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A	
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A	

Bridge No: 34-0006
Component: OBG Trial Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Segment 14AE to Segment 14BE (U-Rib to U-Rib)

This QA Inspector performed Dimension Control Inspection for measuring offset along with ABF QA Inspector on the U-Rib to U-Rib from Cross Beam side towards Bike Path side at a total of 37 locations on Segment 14AE to Segment 14BE between Panel Points (PP) 127.3 to PP 127.5 at the following locations at Bay # 14:

The offset was measured within 50mm from the Deck Panel on U-Rib on the South and North side. The QA Inspector measured the Offset using 1(One) Meter Straight Edge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 13AE (Segment Assembly)

This QA Inspector performed Dimension Control Inspection on the Segment Assembly for the Segment 13AE between Panel Point (PP) 119 -1500mm, PP 119 and PP 119 +1500mm at measured the following at Bay # 14:

Between work point E3 to work point E4 at 4(Four) locations and at 1(One) location between work point E3 to work point E13 and at 1(One) location between work point E4 to work point E14, Total 6(Six) locations.

Flange Height Offset.

Top Web Offset.

Bottom Web Offset.

Flange Offset.

Centre Line Web Sweep.

The QA Inspector measured the Mis-Alignment using 600mm Straight Edge, Carpenter Square, String Line and Measuring Tape.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 13AW (Segment Assembly)

This QA Inspector performed Dimension Control Inspection on the Segment Assembly for the Segment 13AW between Panel Point (PP) 119 -1500mm, PP 119 and PP 119 +1500mm at measured the following at Bay # 14:

Between work point W3 to work point W4 at 4(Four) locations and at 1(One) location between work point W3 to work point W13 and at 1(One) location between work point W4 to work point W14, Total 6(Six) locations.

Flange Height Offset.

Top Web Offset.

Bottom Web Offset.

Flange Offset.

Centre Line Web Sweep.

The QA Inspector measured the Mis-Alignment using 600mm Straight Edge, Carpenter Square, String Line and Measuring Tape.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the

Lead Inspector and Engineer for review and disposition.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer